

Work Order ID 55140

January 7, 2010 8:35:50 AM

Page 1

Item ID: D044-719-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Cabin Floor Protector

Start Date: 07/01/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

10-1-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3281

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D044-719-011 CHG003

S 10/01/20

for ME 10/01/20

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-1-21 100

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2) S 10/01/20

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55140

January 7, 2010 8:35:50 AM

Page 2

Item ID: D044-719-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 07/01/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D044-719-011

Location: _____

PPP Rev: C

Handwritten signature and date: 10/01/28 (10)

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

Handwritten signature and date: 10/01/29

MF

10-1-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 7, 2010 8:35:57 AM

Page 1

Work Order ID: 55140

Parent Item: D044-719-011

Parent Item Name: Cabin Floor Protector

Start Date: 07/01/2010

Required Date: 15/01/2010

Comments: IPP Rev: A 04.09.17 New Issue KJ/JLM

Start Qty: 10.00

Required Qty: 10.00

IPP Rev: B 04.02.02 Material change to Lexan 0.125" DL

IPP Rev C: 07.08.07 Thermoformed in house DL

IPP Rev D: 08.04.14 Material change to Lexan 0.093" DL

D2854-1-100

XS

Manufactured No

110

Each

35.0000

80.0000



Velcro Strip, Looped

10-1-27 B55444 sl

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

35

40490

4

47415

31

D2854-3-100

XS

Manufactured No

110

Each

43.0000

80.0000



Velcro Strip, Hooked

B55445 10-1-27 sl

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43

37862

4

39589

4

40491

4

47416

31

D3281-1

XL

Manufactured No

110

Each

1.0000

10.0000



Floor Protector, Fwd LH

10-1-27 sl (10x)

B55141

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

47339

1

1 x

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

January 7, 2010 8:35:57 AM

Work Order ID: 55140

Parent Item: D044-719-011

Parent Item Name: Cabin Floor Protector

Start Date: 07/01/2010

Required Date: 15/01/2010

Comments:

IPP Rev: A 04.09.17 New Issue KJ/SLM

Start Qty: 10.00

Required Qty: 10.00

IPP Rev: B 04.02.02 Material change to Lexan 0.5" DL

IPP Rev C 07.08.07 Thermoformed in house DL

IPP Rev D 08.04.14 Material change to Lexan 0.3" DL

D3281-2 Manufactured No 110 Each 2.0000 10.0000



Floor Protector, Fwd RH

10-1-27 SL
B55142 B SF

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

40473

1

47340

1

1
1
1

D3281-3 Manufactured No 110 Each 0.0000 10.0000



Floor Protector, Aft LH

B55143 10-1-27 SL

D3281-4 Manufactured No 110 Each 2.0000 10.0000



Floor Protector, Aft RH

8x
B55144 10-1-27 SL

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

40475

1

47342

1

1
1
1

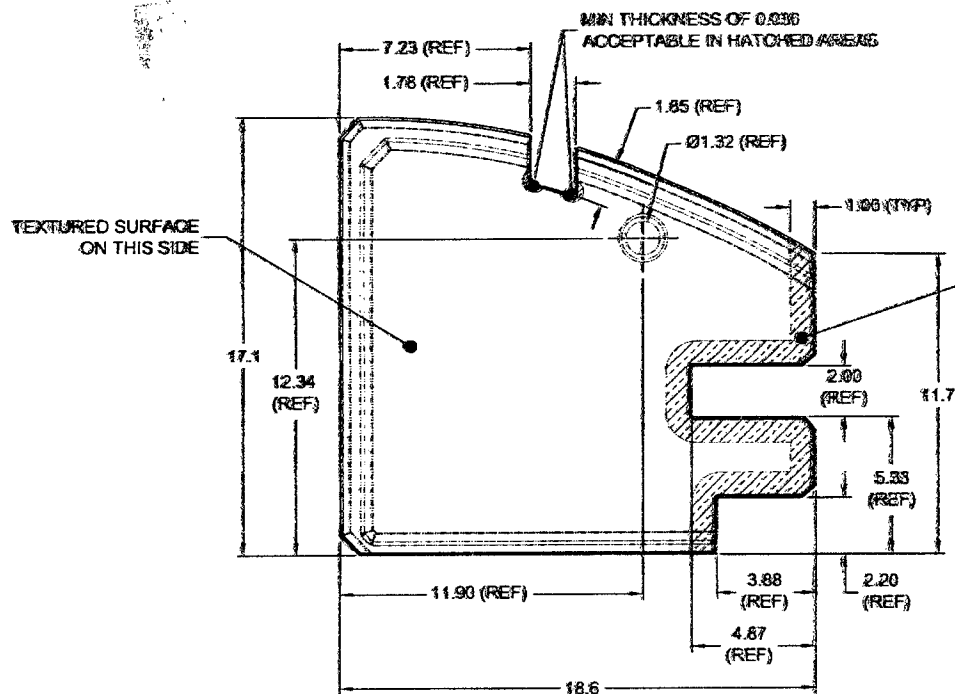
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

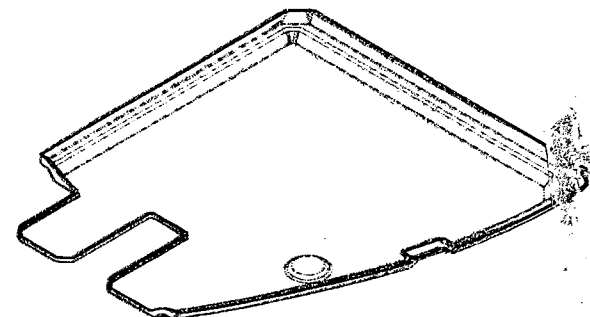
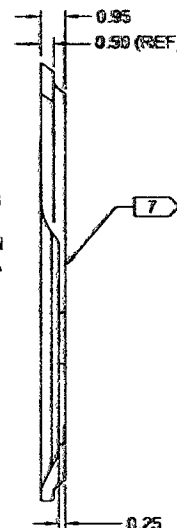


D3281-1 FLOOR PROTECTOR

21-1 NOTES:
 HERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
 MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
 MATERIAL: LEXAN F6006, BLACK No. 701, 0.053" THICK
 (REF DART SPEC MLEXS.093-F6006-02)

FINISH: NONE
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 UNITS: INCHES UNLESS OTHERWISE NOTED
 BREAK SHARP EDGES: 0.010 MAX
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
 WEIGHT: 0.95 lb

MIN THICKNESS
 OF 0.030
 ACCEPTABLE IN
 HATCHED AREA



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 - WORK ORDER
 NO. 55140
 10-1-07

105-0411 WJ

REV.	DESCRIPTION	BY	DATE
D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.060, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A6-1, A6-2, A6-3, A6-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS. COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
DESIGN	DRAWN	DESIGN	DATE
CHECKED	MFG. APPR.	DE APPR.	DATE
APPROVED	DATE	08.03.28	
DART AEROSPACE LTD MANNEBURY, ONTARIO, CANADA DRAWING NO. D3281 TITLE FLOOR PROTECTOR SCALE NTS SHEET 1 OF 4 REV. D			

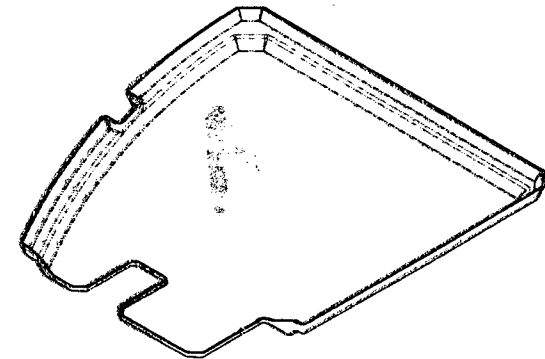
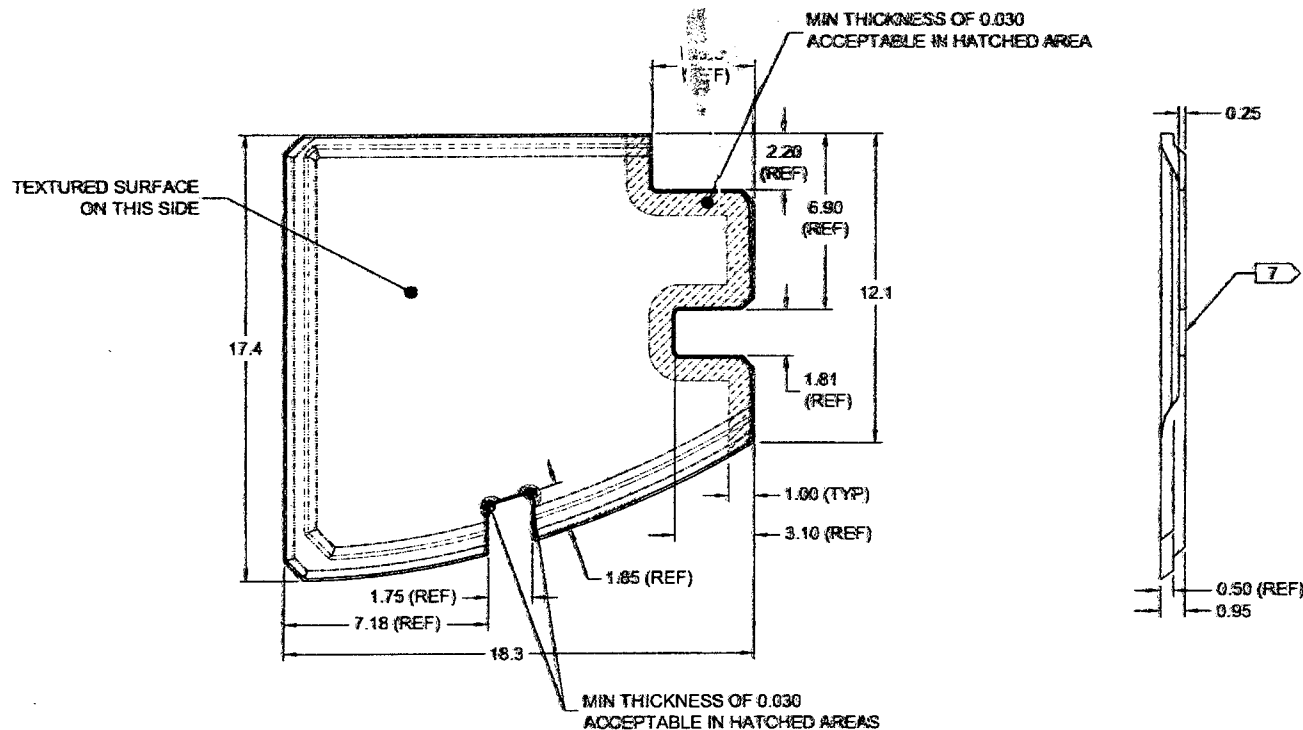
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3281-2 FLOOR PROTECTOR

21-2 NOTES:
 HERMOFORM WITH MOLO D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
 MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
 MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
 (REF DART SPEC MLEXS.093-F6006-02)
 FINISH: NONE
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 UNITS: INCHES UNLESS OTHERWISE NOTED
 BREAK SHARP EDGES: 0.010 MAX
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "XXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
 WEIGHT: 0.97 lb

RELEASED
 08/11/2014

W/O 55-140

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAMMERSBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. D
MFG. APPR.	90	D3281	SHEET 2 OF 4
APPROVED	90	TITLE	SCALE
DE APPR.	90	FLOOR PROTECTOR	NTS
DATE	08.03.28	COPYRIGHT © 2004 DART AEROSPACE LTD	
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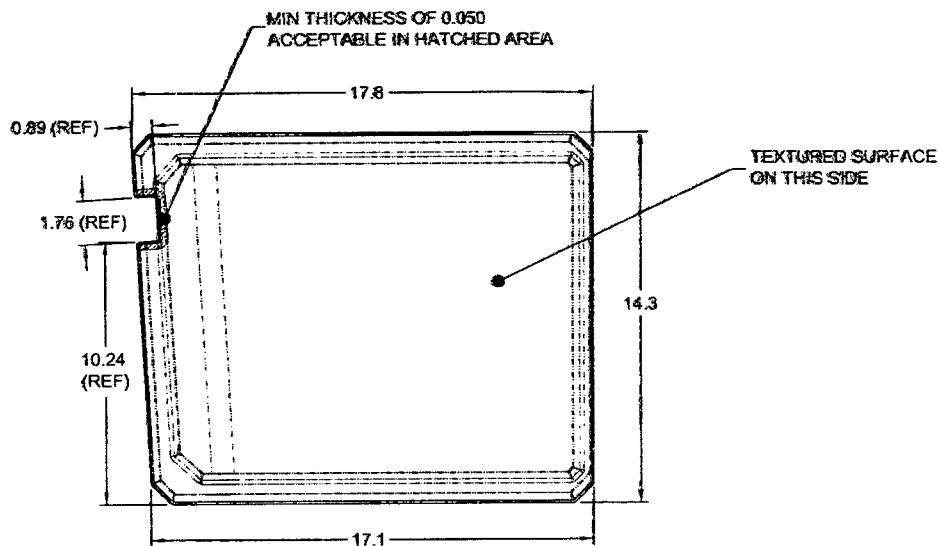
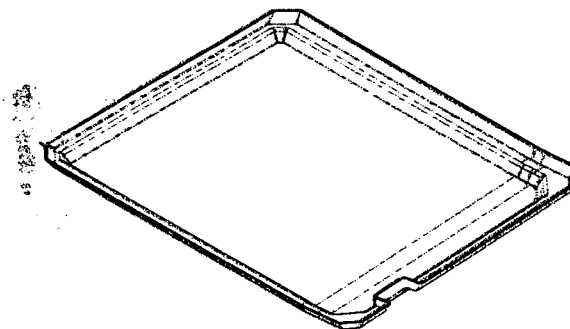
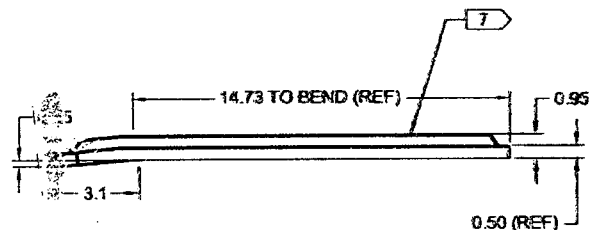
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3281-3 FLOOR PROTECTOR

D3281-3 NOTES:

HERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
 MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
 MATERIAL: LEXAN F6006, BLACK No. 701, 0.0393" THICK
 (REF DART SPEC MLEXS.093-F6006-02)

FINISH: NONE

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.010 MAX

IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS

WEIGHT: 0.87 lb

DESIGN	40	DART AEROSPACE LTD	
DRAWN	RL	HAWKESBURY, ONTARIO, CANADA	
CHECKED	3	DRAWING NO.	REV. D
MFG. APPR.	MD	D3281	SHEET 3 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	FLOOR PROTECTOR	NTS
DATE	08.03.28	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

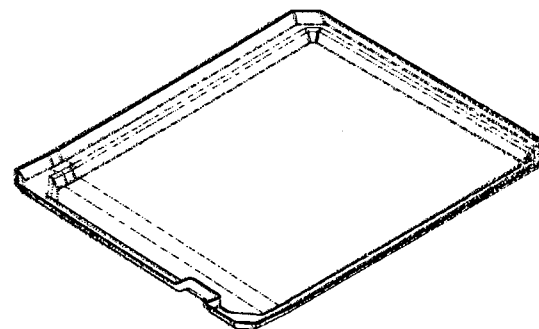
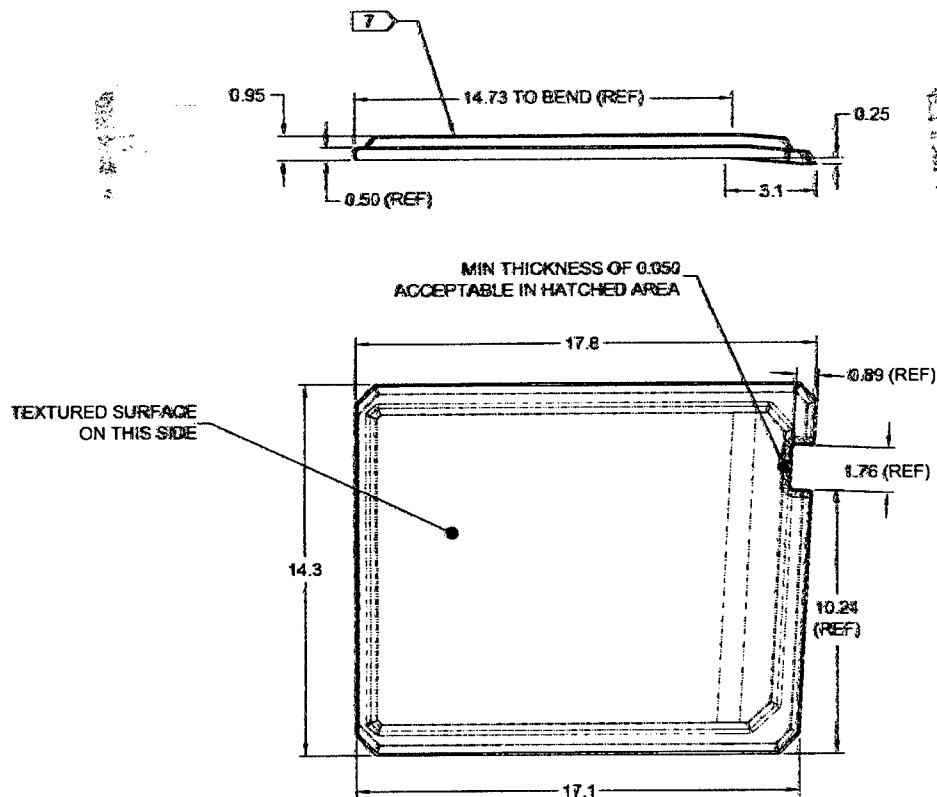
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3281-4 FLOOR PROTECTOR

NOTES:

HERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
 MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
 MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
 (REF DART SPEC MLEXS.093-F6006-02)

FINISH: NONE
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.010 MAX

IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS

WEIGHT: 0.87 lb

DESIGN	W/6 55140	DART AEROSPACE LTD	
DRAWN	PA	HAWKESSBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO. D3281	REV. 0
MFG APPR.	PA		SHEET 4 OF 4
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	FLOOR PROTECTOR	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

2.0 GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

3.0 INSTALLATION PROCEDURE

The Dart D044-719-011 Cabin Floor Protectors should be installed as follows:

- 3.1 Remove any existing floor protection that may interfere with the installation of the D3281-1, D3281-2, D3281-3, or D3281-4 Floor Protectors.
- 3.2 Apply qty(2) 10" long velcro strips to the bottom of all four Floor Protectors as shown in Figure 1. Remove adhesive back.
- 3.3 Place the D3281-1, D3281-2, D3281-3, and D3281-4 Floor Protectors on the cabin floor of the aircraft as shown in Figure 1. Push the trays down so they are firmly seated on the floor (ie. they will not move during flight) and will not interfere with any of the aircraft controls.

NOTE: Previous interior modifications may necessitate minor trimming of D3281-1/-2/-3/-4 to facilitate installation. Trim to fit as required.

NOTE: To clean floor protectors, use mild soap or detergent with warm or cold water. Do not use abrasive or highly alkaline cleaners.

4.0 WEIGHT AND BALANCE

The following is the weight increase associated with the Cabin Floor Protectors. Be sure to subtract the weight of any parts removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-719-011	3.9 lb	0 in	0 in-lb	50 in	195 in-lb
Cabin Floor Protectors	1.8 kg	0 m	0 m-kg	1.27 m	2.3 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D044-719-011	CABIN FLOOR PROTECTORS
1	D3281-1	FLOOR PROTECTOR, FWD LH
1	D3281-2	FLOOR PROTECTOR, FWD RH
1	D3281-3	FLOOR PROTECTOR, AFT LH
1	D3281-4	FLOOR PROTECTOR, AFT RH
8	D2854-1-100	LOOPED VELCRO STRIP
8	D2854-3-100	HOOKED VELCRO STRIP

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Revision: **A**

Date: 04.06.10

W/O:		WORK ORDER CHANGES					
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